

Rush Ship Friday!!!

**Work Order ID 69374**

Tuesday, May 10, 2011 1:25:44 PM

Item ID: D3945-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 5/10/2011 Start Qty: 4.00

Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 5-10-11

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3945

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3945-1

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

B11-5-11

30

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-5-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

0.00

Memo

8 u105/11

counter  
x30

130



Small Fab

Small Fab

Memo

COUNTERSINK AS PER DWG

0.00

0.00

8 u11/05/11 30

140



Brake NC

Brake NC

Memo

Bend as per Dwg

0.00

0.00

28 11/05/12

30

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Reference:

Run Start



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Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

8 11/05/12

0.00

count  
x30

Memo

160



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

Memo

30 BL 11-5-12

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

0.00

Memo

30x 11/05/12

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Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

180

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

115/28 300

190

0.00



Small Fab

Memo

0.00

Small Fab

INSTALL NUT PLATES AS PER DWG

34/05/12 30

200

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

8 w/5/12

counts  
+30

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Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

210

Identify as per dwg & Stock Location: 95

0.00



Packaging

Memo

0.00

Packaging

11/5/12 SL (300)

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/12 [Signature]MF  
11-05-12

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**NOTE:** Date & initial all entries

# Picklist Print

Tuesday, May 10, 2011 1:25:50 PM

Page 1

Work Order ID: 69374

Parent Item: D3945-041

Parent Item Name: Bracket



Start Date: 5/10/2011

Required Date: 5/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.050 		Purchased	No			100	sf	180.0000	0.0118	0.049684	15		
6061-T6 .050 Sheet													

Location	Loc Qty	Loc Code
MAT021	180	
113216	20	
114799	128	
114993	32	

MS21059L3 		Purchased	No			180	Each	134.0000	1		4		
Nut Plate													

Location	Loc Qty	Loc Code
ST301	128	
117423	28	
117505	100	
ST302	6	
116706	6	

MS20426AD3-3 		Purchased	No			180	Each	2,755.000	2		8		
Rivet													

Location	Loc Qty	Loc Code
ST316	2755	
19099	2755	

11-5-11

30

113216

30

11/5/12 8/

20

W/O:		WORK ORDER CHANGES					
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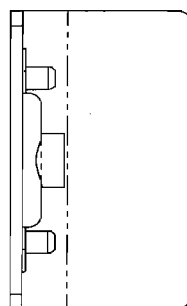
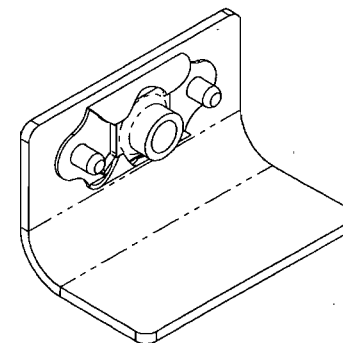
**NOTE:** Date & initial all entries

## PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3945-041	BRACKET
2	1	D3945-1	BRACKET
3	1	MS21059L3	NUTPLATE
4	2	MS20426AD3-3	RIVET

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *69374*

*PL 11-05-10*

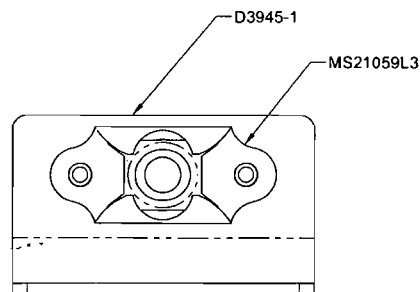


MS20426AD3-3  
2 PL

0.75  
REF

1.25  
REF

**D3945-041 BRACKET**



## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3945-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.01 lbs

RELEASED  
*09/06/16*

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>JP</i>		
CHECKED	<i>JP</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JP</i>	D3945	SHEET 1 OF 3
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	BRACKET	NTS
DATE	09.05.01	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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**NOTE:** Date & initial all entries



8

7

6

5

4

3

2

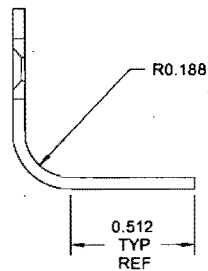
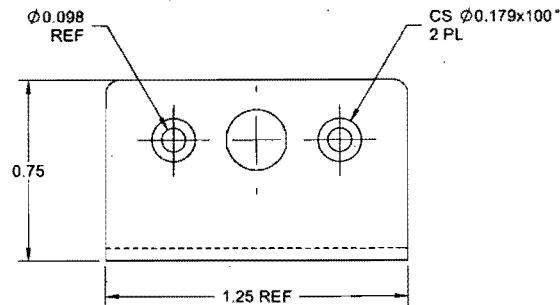
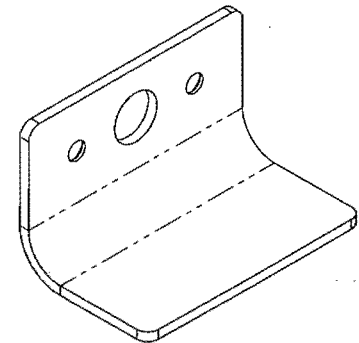
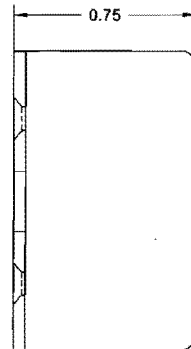
1

D

C

B

A

**D3945-1 BRACKET**

also 69374

RELEASED  
59/206/12/11/12

**NOTES:**

- 1) MATERIAL: MAKE FROM D3945-1F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.01 lbs

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	90	DRAWING NO. <b>D3945</b>	REV. A
MFG. APPR.	90	SHEET 2 OF 3	
APPROVED	90	TITLE <b>BRACKET</b>	SCALE
DE APPR.	90	NTS	
DATE	09.05.01	<small>COPYRIGHT © 2000 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

8

7

6

5

4

3

2

1

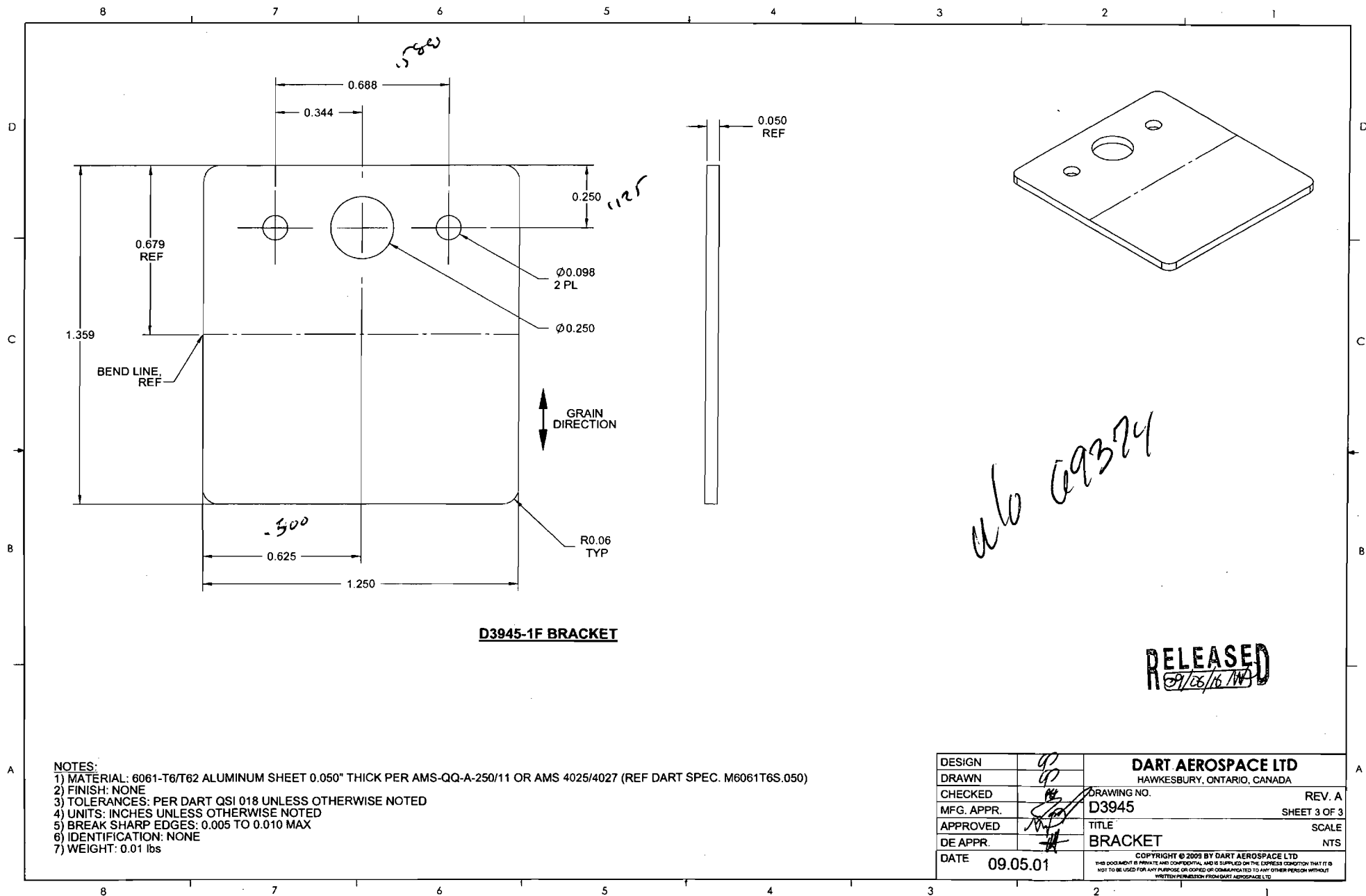
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